Work Order ID 119526 *119526* Page 1 Friday, May 16, 2014 1:01:43 PM Item ID: D3393-041 Accept *N900040100* Setup Start **Revision ID: Item Name:** Battery Lock **Start Date:** 5/15/14 Start Qty: 2.00 **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 2.00 **Customer:** Reference: Run Start Process Plan: MLゴ Date: 14-05-22 Tooling: **Approvals:** Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. **Work Center ID Description Run Hours** Qty Number Stamp Code **Qty Draw Nbr Revision Nbr** D3393 Rev A 100 0.00 Small Fab *100* NOV 0 4 2014 Small Fab 0.00 Memo Small Fab ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT 1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.2-Using the flat cam, fabricate D3369-5 as per Dwg D3369Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten 110 0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab Description Batch A/RN/A

Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number SS Rod_M125059

7 & 14-11-6

DQA:			. Date:			WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:		•	Date:			WORK ORDER NON-	-((JNFU	RIVIAINCE / UP		Wo	rk Order up	date only		AEROSPACE		
Work Orde)r·					DISPOSITION											
WOIK Olde	=1. –				—	Rework			Skid-tube	Crosstube			Water Jet		Engineering		
Part No.						Scrap Use-as-is		1	Machining noforming	Prod. Eng. Coor.				Quality Other			
NCR N	۸o					Suspected Unapproved		Thermoforming Finish Large Fab Compo			-		Supplier				
Root					Desci	ription of work order update	1	Initial	Acti	on		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	1	QC Inspector		
Design																	
Doc/Data																	
Equip/Tooling																	
Handling/Pre																	
Material																	
Operator																	
Offset/Setup		2.]	'												
Process																	
Supplier																	
Training			ŀ														
Transport																	
Unapproved																	
							FA	ULT CA	TEGORY								
Landi	ng Ge	ear				General		_									
		Bending				Bend		Folio/F	Program	Ĺ		Outside Dim	ensions		Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain	•			Over/Under	tolerance		Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ાં		Temperature/Cure		
		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Und	qualified		Part Lost/Mi	ssing		Weld		
	Cuffs					Contamination		Instruct	tions Incomplete/U	nclear		Part Moved			Wrong Stock Pulled		
	Crushing					Countersink		Misalig	ned/off center			Positioned W	Vrong				
	Heat Treat					Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other		
	Inspection Strip in Tube					Drawing		Misread	d	•							
		Marks/Ch	atter			Drill Holes		Off-set			_						
		Turning S	equence			Finish		Out of	Calibration								
			ist in Tub			Fit/Function		Out of	Out of Sequence								

Friday, May 16, 2014 1:01:43 PM

119526

Page 2

Item ID: D3393-041 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Battery Lock *9* Start Date: \ 5/15/14 Start Qty: 2.00 **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 2.00 *9* **Customer:** Reference: Start Run Process Plan: **Approvals:** Date: Tooling: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID Description Qty** Number **Run Hours** Code Stamp Oty 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *120* QC 0.00 Memo **Quality Control** 130 0.00 Small Fab FF NOV 1 0 2014 *130* Small Fab 0.00 Memo Small Fab Apply Crazy `Glue to cap and press into Body DAS 140 QC5- Inspect part completeness to step on W/O 0.00 38 *140* 9-89 OC 0.00 Memo NOV 1 U LUIT Quality Control

DQA:			Date:		-	WORK OPPER NON	DART								
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RIVIAINCE / UI		Wor	k Order up	date only	\neg	AEROSPACE
Maril Ord						DISPOSITION									
Work Orde	er:					Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	No.					Scrap			Machining Small Fab						Quality
					_	Use-as-is		Thermoforming Finisl				Rec/Store/Packaging			Other
NCR No.						Suspected Unapproved		Large Fab Compo							
Root					Desc	ription of work order update	П	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u> </u>	QC Inspector
Design															
Doc/Data															
Equip/Tooling	Ш														
Handling/Pre			11 13												
Material	Щ	, ,													
Operator					1									:	
Offset/Setup	Ш														
Process	Ш										ŀ				
Supplier															
Training															
Transport 🙏	٠.	t week									1	·			
Unapproved								<u>,</u>							
			·				FAI	ULT CA	regory						
Landi	ng Ge	ar				General	_	_					-		
	∐B	ending				Bend		Folio/F	Program		\square	Outside Dim	ensions	-	Pressure/Forced
	\Box	entre No	ot Concer	ntric		BOM/Route	L	Grain			\Box ^c	Over/Under	tolerance	-	Set-up
	\bigsqcup	Cracks				Broken/Damage/Defect	L	Hardwa	ire .		ЩР	art Incorrec	ા		Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Un	nqualified	ШР	art Lost/Mi	ssing	_	Weld
	Cuffs					Contamination		Instruct	ions Incomplete/U	Inclear	P	art Moved	Į		Wrong Stock Pulled
	Crushing					Countersink		Misalig	ned/off center			ositioned W	Vrong _		
	Heat Treat					Cut Too Short		Mislabe	eled		P	ower Loss/	Surge		Other
	Inspection Strip in Tube					Drawing		Misrea	d		-				· · · · · · · · · · · · · · · · · · ·
		/larks/Ch	atter			Drill Holes		Off-set							
	T	urning S	equence			Finish		Out of	Calibration						
	\square	Vave/Tw	ist in Tub	e		Fit/Function		Out of	Out of Sequence						-

Work Ord Friday, May 16						Page 3						
Item ID: Revision ID: Item Name:	D3393-041 Battery Lock		•	Accept	*N900	040	100)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date Reference:	5/15/14 : 5/15/14	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:	ID:						• • •
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Date:				Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 150 *150* Packaging Packaging	D	Operation Description Identify as per dwg & Stoc	k Location (550)	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp NOV 1 0 2014
160 *160* QC		QC21- Final Inspection - V	Vork Order Release	0.00					***	14/	11/1	1

0.00

Memo

Quality Control

DQA:			Date:										DAR.	T
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF			.	AEROSPAC	E
QA Closed:			Date:							W	ork Order up	date only		
Work Ord	ar.					DISPOSITION								
WOIK OIG	C1.					Rework	Rework			Crosstube	7	Water Jet	Engineering	
Part I	No.					Scrap		Skid-tube Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
						Use-as-is	· - - - - - - - - -				Rec/Stor	re/Packaging	Other	
NCR f	٧o.					Suspected Unapproved]	Supplier		
Root					Desci	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n QC Inspector	
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre						·								
Material							ŀ							
Operator		ŀ												
Offset/Setup														
Process														
Supplier	L	<u> </u>												
Training		ļ	i											
Transport														
Unapproved					<u> </u>		<u> </u>	-	<u></u>					
							FA	ULT CA	TEGORY			**		
Landi	ng (1			_	General		1 <i>(</i> -		_	٦			
	<u> </u>	Bending			<u> </u>	Bend	<u> </u>	4	Program	-	Outside Dim	- F	Pressure/Forced	
	_	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	F	Set-up	
		Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	, , , , , , , , , , , , , , , , , , ,	Temperature/Cure	
	<u> </u>	Crimp/Kink/Ripple/Wave				Burrs	_	4	ion Incomplete/Un		Part Lost/Mi	ssing	Weld Wrong Stock Pulled	1
	_	Cuffs				Contamination	⊢	4	tions Incomplete/U	nciear	Part Moved	\/************************************	wrong Stock Pullet	1
•	Crushing				-	Countersink		•	gned/off center	<u> </u>	Positioned V Power Loss/		Other	
	Heat Treat			T b	<u> </u>	Cut Too Short		Mislabe			Trower rossy.	ouige [Louiei	
	Inspection Strip in Tube				\vdash	Drawing Drill Holos		Misread Off-set						_
	Marks/Chatter Drill Holes Turning Sequence Finish						\vdash	4	Calibration					
	\vdash	1			<u> </u>	Finish	\vdash	4	Calibration Sequence					
	t	Wave/Twist in Tube Fit/Function							sequence					

Picklist Print

Friday, May 16, 2014 1:01:47 PM

Work Order ID: 119526

119526

Parent Item:

D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 5/15/14

Required Date: 5/15/14

Stort Ot., 2.00

								8	Start Qty: 2.00)	Require	d Qty: 2.00
Comments:	IPP Rev:A N	ew Issue 05	5-11-22	JLM								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
5/16WC		Purchased	No			100	Each	441.0000	2	4		
5/16WC Washer									**		FF	NOV 0 4 2014
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code				
				ST365			441				_	
9567K21		.	.,		M127961		441		.	7	_	
	J.	Purchased	No			100	Each	9.0000	2	4		MOVED -2014.4
*9567K21	×	•							**		FF	3014 (177 - 170)(4:4
Polyetheline Cap				Location	9254	Loc	Ωtv	Loc Code		4	•	
				ST381	· ·	1.00	9	Luc Code		•		
				01301	120743		9		_		_	
D3373-1		Manufactured	No	•		100	Each	26.0000	1	2	-	
D3373-1	•	•							**		FF	NOV 0 4 2014
				Location	1	Loc	<u>Oty</u>	Loc Code				
				GA			20				_	
4					105986		20		` _	2	_	
				ST040	74960		6			-	_	
D3393-1		Manufactured	No		74862	100	6 Each	11.0000	1	2	_	
D3393-1 Battery Lock Casing	r	Manufactured	110			100	Lacii	11.0000	**	2	FF	NOV D 4 20114
				Location		Loc	Otv	Loc Code				,
				ST492	120136	<u> 2000 - </u>	11	<u> </u>		£		
				·- -	102336		1				_	
•					110674		10		_		_	

DQA:		Date:				_						TOART				
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only											
Mark Order			·		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Work Order: Part No.		-			Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	_	Water Jet d. Eng. Coor. re/Packaging	Quality				
NCR No.					Suspected Unapproved		mem	Large Fab	Composite	_ Rec/stor	Supplier					
Root				Desc	ription of work order update		nitial	Actio	on	Sign &						
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n QC Inspector				
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																
						FA	ULT CAT	regory								
Landing	Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Trea Inspectio Marks/Cl	at on Strip in hatter Sequence	e/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Undicions Incom	·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other				
	Wave/Tv	vist in Tub	oe		Fit/Function		Out of S	Sequence			·					

الا أحر الا

Picklist Print

Friday, May 16, 2014 1:01:47 PM

Page 2

Work Order ID: 119526

Parent Item:

D3393-041

Parent Item Name: Battery Lock

119526

D3393-041

Start Date: 5/15/14

**

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

D3393-3

Manufactured

No

140

Each

20.0000

FF

NOV 0 4 2014

Cam Lock Shaft

Location Loc Code Loc Oty ST041 20 101110 1 108529 7 109126 12

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Wo	ork Order up	odate only	\neg	AEROSPACE	
Q, Closea.						DISPOSITION										
Work Orde	er:					DISPOSITION				AGAINSI	UE	PARTMENT,	/PROCESS			
						Rework			Skid-tube	Crosstube			Water Jet		Engineering	
Part N	۱o					Scrap			Machining	Prod. Eng. Coor.				Quality		
. ,						Use-as-is		Thermoforming Finish			-	Rec/Sto	re/Packaging	_	Other	
NCR No.						Suspected Unapproved			Large Fab	Composite			Supplier		L l	
Root	T				Desci	ription of work order update		nitial	Acti	ion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u>1</u>	QC Inspector	
Design																
Doc/Data																
Equip/Tooling	Ш															
Handling/Pre																
Material																
Operator																
Offset/Setup			-													
Process	Ш															
Supplier	Ш															
Training	Ш															
Transport																
Unapproved					····		<u> </u>		<u> </u>			-	· · · · · · · · · · · · · · · · · · ·			
			-				FA	ULT CA	TEGORY							
Landii						General	_]:_/n	\			Outside Dim	ansians [_	Pressure/Forced	
	-	ending				Bend BOM/Bouts	⊢	₹ `	Program		-	Over/Under	ŀ	_	Set-up	
	_		t Concer	ntric	_	BOM/Route		Grain			\vdash	Part Incorred	ŀ		Temperature/Cure	
	-	Cracks				Broken/Damage/Defect	_	Hardwa		auglified	⊢	Part Lost/Mi	· · ·		Weld	
	Crimp/Kink/Ripple/Wave					Burrs	_	1 '	ion Incomplete/Un			Part Moved	331118		Wrong Stock Pulled	
	Crushing					Contamination Countersink	-	-i	tions Incomplete/U gned/off center	nicieal		Positioned V	l Vrong		Willia Stock i diled	
	Crushing Heat Treat					Cut Too Short	-	Mislabe	•		\vdash	Power Loss/	· ·		Other	
	Inspection Strip in Tube					Drawing	-	Misread				1, 0410, 2033/				
	Marks/Chatter					Drill Holes	\vdash	Off-set						**		
	\blacksquare		equence		\vdash	Finish	\vdash	ł	Calibration					-		
	_	_	ist in Tuk		\vdash	Fit/Function		1	Sequence							
						1	1	1								